

Date: Wednesday, 05/12/2007 3:44:48 PM  
User: Linda Lacelle

# Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DUCT
Job Number	: 36162		
Estimate Number	: 12175		
P.O. Number	: <i>N/A</i>	Part Number	: D34761
This Issue	: 05/12/2007	S.O. No.	: <i>N/A</i>
Prsht Rev.	: NC	Drawing Number	: D3476 UNDER REVIEW
First Issue	: <i>N/A</i>	Project Number	: N/A
Previous Run	: 34396	Drawing Revision	: A
	Type : SMALL /MED FAB	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 12/12/2007
Checked & Approved By	: <i>[Signature]</i>	Qty:	10 Um: Each
Comment	: Est Rev:A New Issue 06-02-03 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S26GA	304/316 0.018 SHEET
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Comment: Qty.: 0.4374 sf(s)/Unit Total : 4.3743 sf(s)  
304/316 0.018 SHEET  
Batch: *105591* *B 07-12-5*

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET  
Cut as per Dwg D3476  
Dwg Rev: *A*  
Prog Rev: *A*

*B 07-12-5*

*(10)*

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*B 07-12-5*

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

*2/12/06*

*(10)*

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr if necessary.

2-Roll as per Dwg D3476

3-Spot weld as per Dwg D3476 and Dart QSI 018

*mf*

*07-12-10*

*(10)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 02/12/12  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 05/12/2007 3:44:48 PM  
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Drawing Name: DUCT

Job Number: 36162

Part Number: D34761

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC11

VISUAL INSPECTION OF SPOT WELDING



Comment: VISUAL INSPECTION OF SPOT WELDING

SB 07/12/10

10

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/12/10

10

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 103

Ca 2/12/11 (10)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

SB 07/12/10 (10)

Job Completion



u 07/12/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

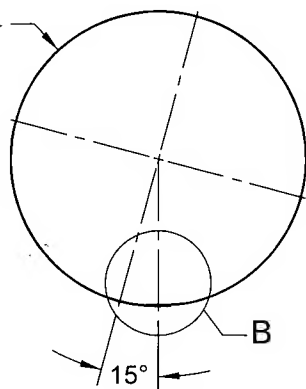
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

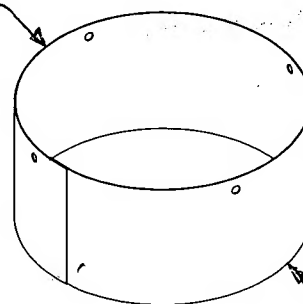
**PRELIMINARY ISSUE**  
07.12.04

DESIGN 13	DRAWN BY 13	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. <b>D3476</b>	REV. A SHEET 3 OF 7
DATE <b>06.01.27</b>		TITLE <b>BLOWER MOTOR ADAPTER</b>	SCALE 1:4

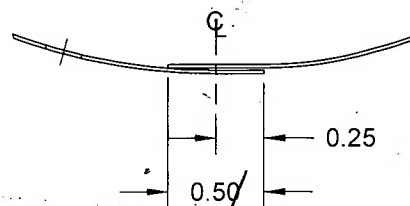
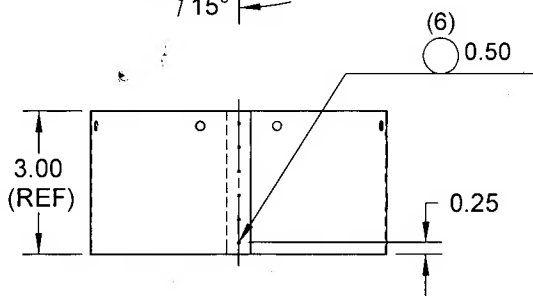
FORM TO FIT  
AS SHOWN  
IN ISOMETRIC  
VIEW.



FORM Ø TO  
FIT 26D71  
BLOWER MOTOR.

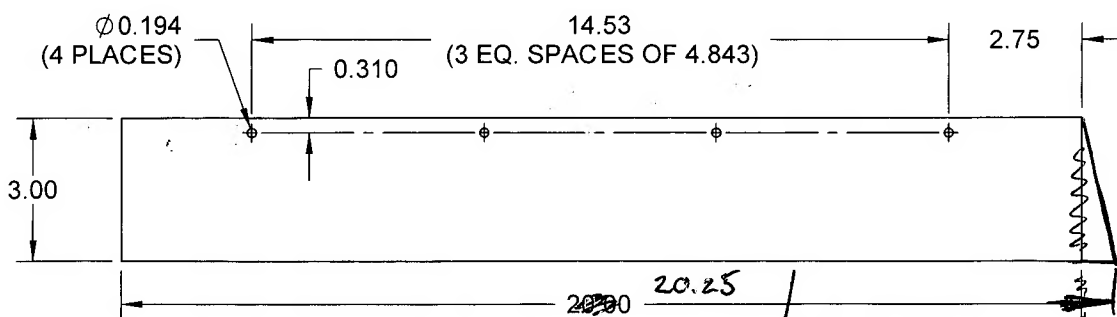


FORM Ø TO FIT  
D3476-3 DOME



DETAIL B  
SCALE 1:1

**D3476-1 DUCT**



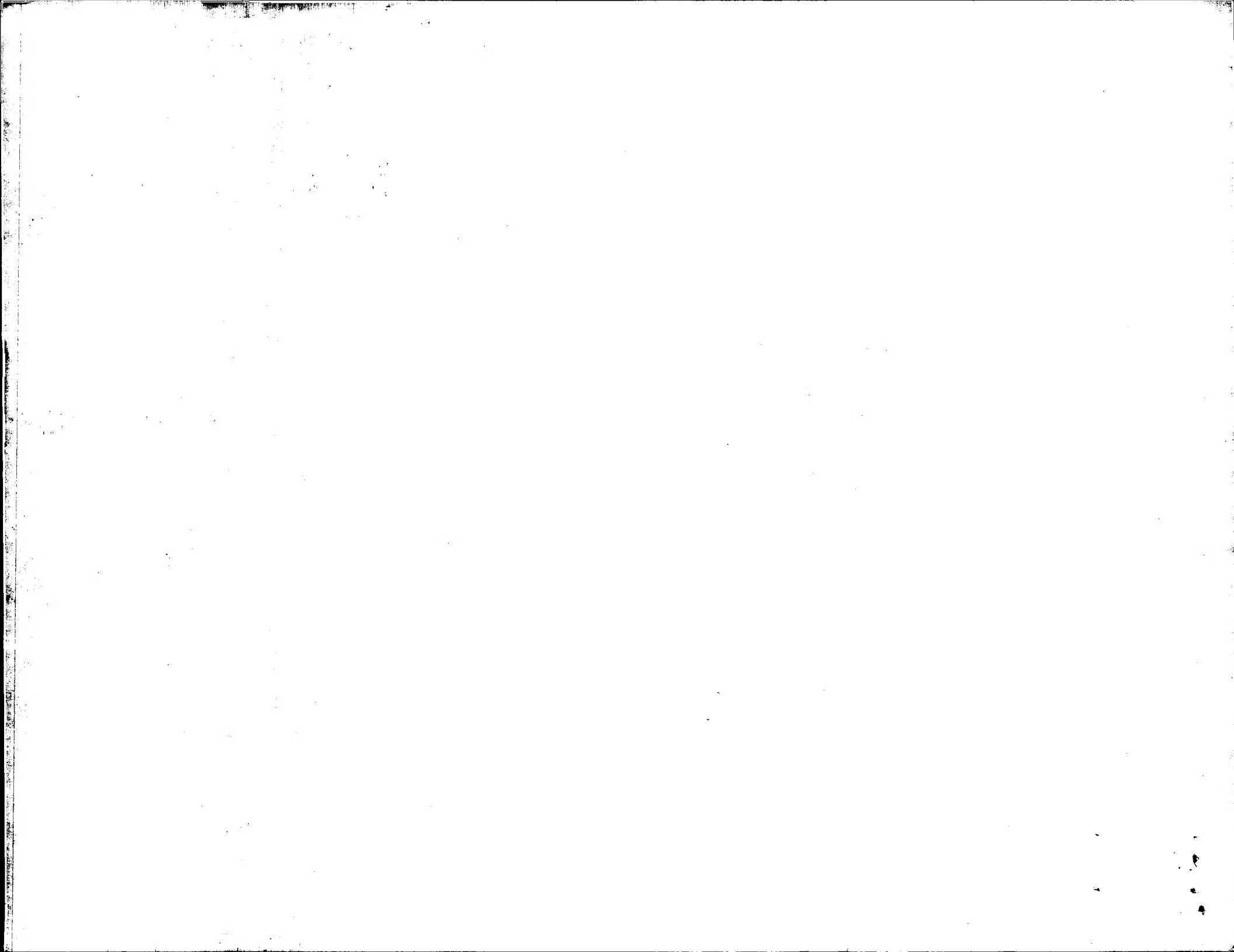
**D3476-1F DUCT FLAT PATTERN**

**NOTES:**

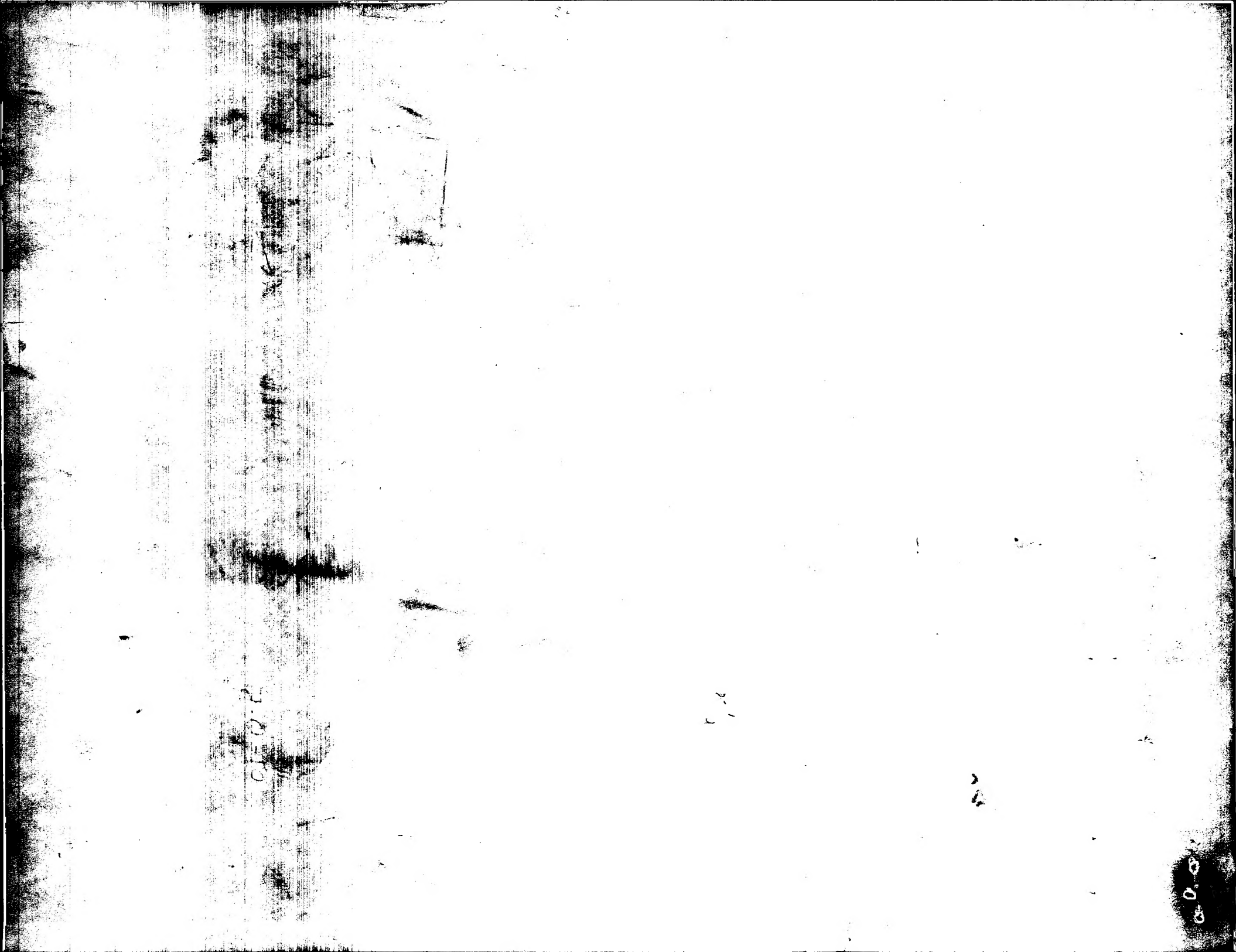
- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) SPOT WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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**SPOT WELD TEST RECORD**  
**AMS-W-6858A**  
**CLASS 'C'**

**TEST NO#:** 42

**EMPLOYEE:** Melani Fawcett

**PART NUMBER:** D 3476-1

**JOB NUMBER:** B 36162

**MATERIAL TYPE:** 304L

**MATERIAL THICKNESS:** 0.05

**GROUP SPECIFICATION**



**Group 1: Aluminum & magnesium**



**Group 2: Iron; nickel; cobalt**



**Group 3: Titanium** SS

**TEST RESULTS**

	PASS	FAIL
VISUAL:	[ <input checked="" type="checkbox"/> ]	[ <input type="checkbox"/> ]
PENETRATION:	[ <input type="checkbox"/> ]	[ <input type="checkbox"/> ]
PULL STRENGTH:	[ <input checked="" type="checkbox"/> ]	[ <input type="checkbox"/> ]

PSI Reading: \_\_\_\_\_

**Qualified in accordance with standard AMS-W-6858A and QSI 004 (ref: 4.3)**

**DATE OF TEST COUPON:** 07/12/10  
**QUALIFIER:** SB

